

Work Order ID 61944-2

~~PRELIMINARY ISSUE~~

10.00.01

Monday, September 13, 2010 8:18:27 AM

Page 1

Item ID: D4172-9

Revision ID: PRELIM

Item Name: Angle

Start Date: 9/10/2010 Start Qty: 6.00

Required Date: 9/17/2010 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

QC:

Date: 10-9-13

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4172

PA1

100

0.00



Small Fab

Memo

0.00

- 1- Cut to length as per dwg
- 2- Use DT9662 to drill holes in angle, open to size as per dwg
- 3- Deburr holes

110

QC5- Inspect part completeness to step on W/O

0.00 - inspect to PA1



QC

Memo

0.00

Quality Control

Dry only
8/10/2016

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10/10/2016

x6 6

9/30/09/16 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61944

Monday, September 13, 2010 8:18:27 AM



Page 2

Item ID: D4172-9

Accept

Revision ID: PRELIM



Setup Start



Item Name: Angle

Stop



Start Date: 9/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00

10-9-16



QC

Memo

0.00

Quality Control

(6)

d.

140

Identify as per dwg & Stock Location

0.00

tar



Packaging

Memo

0.00

Packaging

AT 10-10-01 (x1)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/04

10-10-01

(1)

POSITIVE RECALL

EFFECTIVE *10-21-13*

AUTH *L*

RELEASED *10-21-13*

DATE *10.10.01*

Released Per DWG

DATED 10.09.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, September 13, 2010 8:18:31 AM

Page 1

Work Order ID: 61944

Parent Item: D4172-9

Parent Item Name: Angle



Start Date: 9/10/2010

Required Date: 9/17/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.09 new issue DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6203

Manufactured No

100

f

9.5000

0.0625

0.394737



Angle Extrusion



Handwritten signature and date: 9/10/09/15

Location

Loc Qty

Loc Code

MAT

9.5

45501

9.5

Handwritten: 0.394737

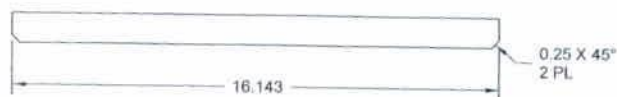
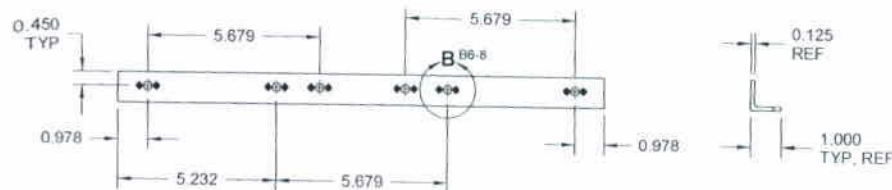
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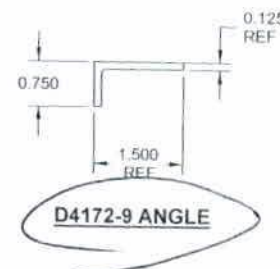
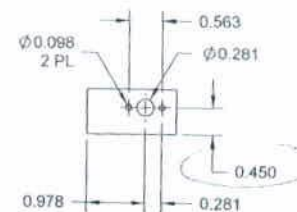
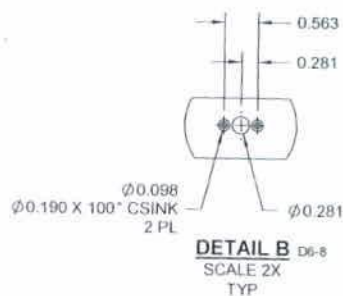
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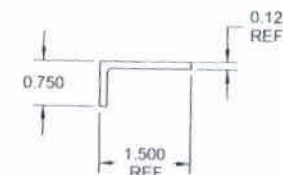
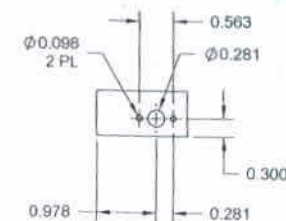
NOTE: Date & initial all entries



D4172-7 CROSSBAR



D4172-9 ANGLE



D4172-10 ANGLE

PRELIMINARY ISSUE
10.09.08

- NOTES**
- 1) MATERIAL
D4172-7: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.00 X 1.00 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6207
D4172-9/-10: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.50 X 1.50 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6203
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/-10 = 0.01 lbs EACH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PAI
MFG. APPR.		D4172	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		POD MOUNTING FRAME ASSY	NTS
DATE	10.09.03	COPYRIGHT © 2010 BY DART AEROSPACE LTD	

Handwritten: 6/21/14
B10-9-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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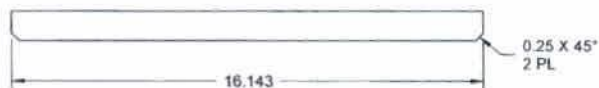
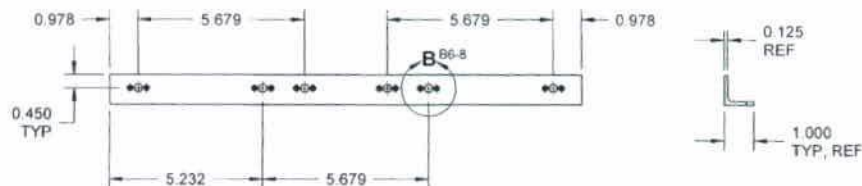
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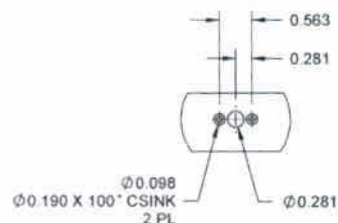
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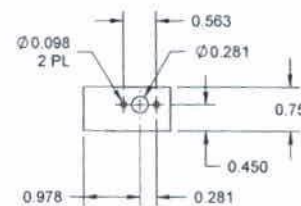
D4172-7 CROSSBAR



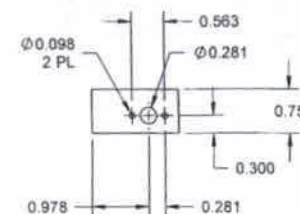
DETAIL B
D6-8
SCALE 2X
TYP

NOTES:

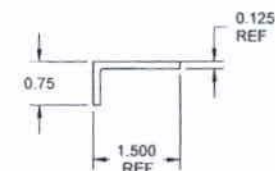
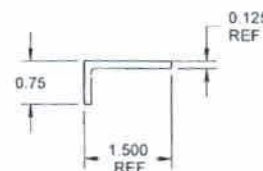
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PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6203
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/-10 = 0.01 lbs EACH



D4172-9 ANGLE



D4172-10 ANGLE



61944

RELEASED
2010-09-29

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4172 REV. A
MFG. APPR.		SHEET 7 OF 7
APPROVED		TITLE SCALE
DE APPR.		POD MOUNTING FRAME ASSY NTS
DATE	10.09.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD